

# Work Order ID 81042

**\*81042\***

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March-07-12 7:45:17 AM

Item ID: D412-698-015

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Door Support

Stop **\*NS2\***

Start Date: 07/03/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/07

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-698	Rev E
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100

DOCUMENT CONTROL

0.00

**\*100\***

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

*JB*

*Sizkulas*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*JB*

*SP*

*12/04/04*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*Sizkulas*

*(+D)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81042****\*81042\***

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Item ID: D412-698-015

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Door Support

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Start Date: 07/03/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-015

Location:

PPP Rev:

BSP12-04-05

140

0.00

**\*140\***

QC21 - Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/4/10MF  
12-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81042

\*81042\*

Parent Item: D412-698-015

\*D412-698-015\*

Parent Item Name: Door Support

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM  
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10L	NAS1149D0332J	Purchased	No			110	Each	0.0000	12	60	✓		
<b>*AN960.ID10I *</b>									**	120644	JB	SP	
Washer D3200-1		Manufactured	No			110	Each	5.0000	2	10	✓		
<b>*D3200-1*</b>									**	5x 29034	JB	SP	
Door Post Block													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST033			5					
					68969			5		5x 968969			
D3200-3		Manufactured	No			110	Each	10.0000	2	10	✓		
<b>*D3200-3*</b>									**		JB	SP	
Door Wedge					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST033			10					
					76214			10		76214			
D3201-1		Manufactured	No			110	Each	2.0000	2	10	✓		
<b>*D3201-1*</b>									**	9x 19035	JB	12/04/04	
Doubler					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST033			2					
					68968			1					
					71597			1		71597			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 81042

Parent Item: D412-698-015

Parent Item Name: Door Support

\*81042\*

\*D412-698-015\*

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 5.00

Required Qty: 5.00

D3201-3

Manufactured No

110 Each

27.0000

\*D3201-3\*  
Doubler

① 5  
\*\*

✓ JB SP

Location

Loc Qty

Loc Code

ST033

27

71661

27

110 Each

9.0000

D3201-4

Manufactured No

\*D3201-4\*  
Doubler

① 5  
\*\*

71661 ✓ JB SP

Location

Loc Qty

Loc Code

ST033

9

69026

9

110 Each

3,552.000

MS21042L3

Purchased No

\*MS21042L3\*  
Nut

① 60  
\*\*

69026 ✓ JB SP

Location

Loc Qty

Loc Code

ST300

3552

117441

16

117885

32

118451

5

118927

3

119017

3316

119075

180

110 Each

55.0000

MS24693-S277

Purchased No

\*MS24693-S277\*  
Screw

① 60  
\*\*

6x120986 JB 12/04/04  
[SP]

Location

Loc Qty

Loc Code

ST288

55

117591

1

119819

54

54x119819

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



## 7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty 015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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\*5\*

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Reference:

Approvals:

Process Plan: MCT

Date: 12/03/07

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN D412-698	Rev E								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	<b>Memo</b>	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-698-015 CHG001								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	<b>Memo</b>	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

MCT 12/04/04  
(5)